

5263948



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5785-1

Job Sheet 208154



Part No: D5785-1

Job Qty: 12 pcs

DAS

21

3-89

Part Name: Lid Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/20

Job Tracking No:

Due Date: 3/31/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.14.01 JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 20/03/12 AUTH JAR

RELEASED DATE



Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	3/31/20		0.17	0.75	Waterjet - Flow		
							Waterjet - Omax		dc 20/03/13
110	QC 2	12 pcs	3/31/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		dc 20/03/13
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
120 QC 8	12 pcs	3/31/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	12 pcs	3/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

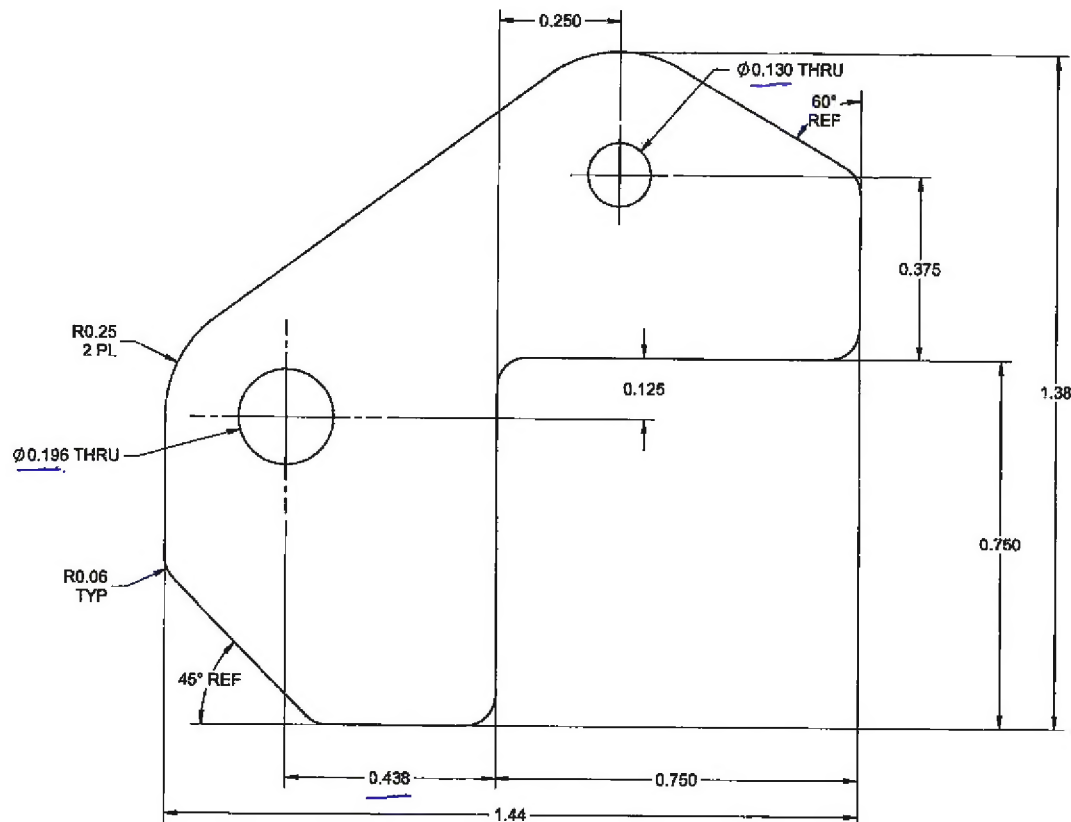
DAS
40
9-89
MAR 17 2020

MAC

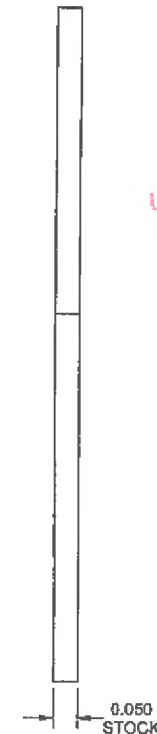
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	3/31/20	0.00 0.00	QC 21 - SA - 21	348
				QC 21 - SA - 70	11
				QC 21 - SA - 53	
Part Op 100 - Cut D5785-1 as per dwg Prng Rev: <u>A</u> Dwg Rev: <u>A</u> Deburr as required Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: <u>W7004</u>) 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S18GA	304/316 .050 Sheet	.1728 sf (.0144 ea)	100-Waterjet - Flow - 1	5243464	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S18GA	0	527	0	
Part Specifications					
Specifications could not be found.					

MAR 17 2020

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208154



D5785-1 BRACKET
(DERIVED FROM AERO DESIGN P/N 36273-01)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #18 GA (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs
- 8) ALL NON-DIMENSIONED FEATURES WITHIN 0.030 OF "D5785-1-REVA.DXF"

RELEASED

2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	REV. A
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	SHEET 2 OF 3
MFG. APPR.	DD	D5785	SCALE
APPROVED	NO	TITLE	NTS
DE APPR.	CP	HANDLE BRACKET	
DATE	20.01.09	COPYRIGHT © 2020 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045418**



Supplier: ACI001-VC
Acier Quellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045418

PO Date: 12/17/19

Due Date: 12/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: QUOTE NO. SOU0230636

DEC 17 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M6063T5C.75X.75W.125			6063-T5 Channel 0.750" x 0.750" x 0.125" wall receive ft	Firmed -		12/20/19	21 ft	0 ft	21 ft	\$1.006/ft	\$21.13
									21 ft				
2		M6063T5A0.750W.063			6063-T5 Angle .750 X.750 X.063 WALL receive ft	Firmed -		12/20/19	21 ft	0 ft	21 ft	\$0.3757142/ft	\$7.89
									21 ft				
3		M304S18GA			304/316 .050 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		12/20/19	320 sf	0 sf	320 sf	\$5.6679375/sf	\$1,813.74
									320 sf				

**ACIER OUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT*CR 80*

CO00184919

Billed to	Shipped to	Customer N°	CLI0001056
DART AEROSPACE LTD		Date	2019/12/17
1270 , ABERDEEN ST.	1270 , ABERDEEN ST.	Delivery date	2019/12/19
HAWKESBURY, Ontario, K6A 1K7	HAWKESBURY, Ontario, K6A 1K7	Your order N°	POHB045418
		Processed by	Josianne Bourdon
		Salesman	JOSIANNE BOURDON
Instruction	Delivery Route	Carrier	OUELLETTE VALLEYFIELD
F-M	5 + <i>WRAP</i> <i>Pallets 4 V8</i>	Credit Terme	Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CHANNEL ALU 3/4 X 3/4 X 1/8 6063-T5 * CHAL-343418 1981 1 X 21' POHB045418 LINE 1 CAST; 19193172	6.17	21.00	PI_\$CLB		21'						
2 ANGLE ALU 3/4 X 3/4 X 1/16 C 6063-T5 * AAL-3434116 1361 1 X 21' POHB045418 LINE 2 CAST 41324	2.25	21.00	PI_\$CLB		21'						
3 SHEET SS 18G SS304-2B DART FESSD-18G3042B-V 12468 10 X 4' X 8' POHB045418 LINE 3 HEAT YU187124 PACKAGING	672.00	320.00	PI2_\$CLB		10X						
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G483042B 3402 2 X 4' X 8' POHB045418 LINE 4 HEAT D73E	336.00	64.00	PI2_\$CLB		2X						
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G483042B 3412 2 X 4' X 8' POHB045418 LINE 5 HEAT LZ25HC10	209.98	64.00	PI2_\$CLB		2X						

LINE 7

MATERIAL RECEIPT INSPECTION FORM

PC113045418

MATERIAL: M304S/PCA

PO / BATCH NO.: PC113045418

DATE: DEC 24 2019

5243464

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: .050

QUANTITY RECEIVED: 3205P

THICKNESS RECEIVED: .050

QUANTITY INSPECTED: 3205P

SHEET SIZE ORDERED: 4' x 8'

QUANTITY REJECTED: 45P

SHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	CIRCLED SPOTS ON SHEET (1)
CORRECT FINISH	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORROSION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	ASTM A240
CORRECT THICKNESS	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
PHOTO REQUIRED	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	HPC Y0187124
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>82</u> <u>6-89</u>	SIGNED OFF BY: _____
DATE: <u>DEC 24 2019</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

467 YU187124

M 304S 1864

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL AISI 304/316 SS SHEET
(ANNEALED)

DAS
82
3-89

DEC 24 2019

SPECIFICATION: MIL-S-5050
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

FINISH:

FINISH	IDENTIFIER
UNPOLISHED No. 1	1P
UNPOLISHED No. 2D	2D
UNPOLISHED No. 2B	NONE
POLISHED No. 3	3P
POLISHED No. 4	4P
BUFFED No. 6	6P
BUFFED No. 7	7P
BUFFED No. 8	8P

PART NUMBER: M304S TT GA #P
GA

WHERE "TT" = GAUGE THICKNESS
WHERE "FP" = FINISH IDENTIFIER

EG. 16 GAUGE SS SHEET 2B FINISH = M304S16GA
EG. 16 GAUGE SS SHEET No. 4 POLISHED = M304S16GA4P

GAUGE THICKNESS REFERENCE:

<u>GAUGE</u>	<u>NOM. THICK.</u> <u>(IN)</u>	<u>THICKNESS</u> <u>RANGE (IN)</u>
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.066
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.08375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176
7	0.1875	0.182 - 0.194
6	0.2031	0.194 - 0.212
5	0.2188	0.201 - 0.228
4	0.2344	0.225 - 0.243
3	0.2500	0.236 - 0.262
2	0.2656	0.264 - 0.278
1	0.2813	0.289 - 0.293
0	0.3125	0.301 - 0.325

RELEASED

2015 FEB 04

ECN 15-527 *u*

D	ADDED GAUGES 0-7.	AJS	15.01.06
C	DEFINED FINISH OPTION (ZN C8) AND EXAMPLE OF MATERIAL. FIN WITH FINISH THINER THAN 28 (ZN B5).	MB	12.06.20
B	REFORMAT DWG. ADD ASTM/ASME SPECS (ZN C8-1). ADD GAUGE REF (C8-1). REF PAR 06-020A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. M304S TITLE 304/316 SS SHEET COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF THIS DOCUMENT OR THE INFORMATION CONTAINED HEREIN IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.		DRAWING NO.	REV. D
DATE	15.01.06	TITLE	SHEET 1 OF 1
		304/316 SS SHEET	SCALE
			NYS

FESS- 18G483042B

TRA 3686 52742

MILL TEST CERTIFICATE

Invoice No.: SQCAEW8602TE6

Steel Grade: AISI 304L

Date: 2018/07/25

Surface Finish: 2B

Page: P02/P04

Goods: STAINLESS STEEL COLD ROLLED SHEETS

Specification: ASTM A240/A480

Certificate No.: PTTW028604TE6

Product ID	Chemical Composition (%)										Mechanical Properties					
	C	Si	Mn	P	S	Ni	Cr	N				Tensile Test			Hardness Test	
												Y.S. (Mpa)	T.S. (Mpa)	EL (%)	HRB	HV
75S43073B-23	0.018	0.360	0.760	0.037	0.004	8.01	18.09	0.038				297	647	50.0	82	162
75S43073B-24	0.018	0.360	0.760	0.037	0.004	8.01	18.09	0.038				297	647	50.0	82	162
75S43476-7	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-8	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-9	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-A	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-B	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-1	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-2	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
76S87832A-1	0.024	0.380	1.370	0.029	0.002	8.03	18.30	0.036				341	683	52.0	90	191
Product ID	Heat No.	SIZE						PCS	Remarks							
75S43073B-23	YU280024	16GA X 60" X 120"						21	REFERRING TO ASTM SPEC PONUMBER: 18-P-266 LCNUMBER: DC HMN812260 OBLNUMBER: KHHMTRJ7829 CONTAINERNUMBER: MEDU7714189, MEDU6166285 Manager Of QA Dept. K. C. W.							
75S43073B-24	YU280024	16GA X 60" X 120"						20								
75S43476-7	YU187124	16GA X 48" X 96"						49								
75S43476-8	YU187124	18GA X 48" X 96"						49								
75S43476-9	YU187124	18GA X 48" X 96"						49								
75S43476-A	YU187124	18GA X 48" X 96"						49								
75S43476-B	YU187124	18GA X 48" X 96"						54								
75S43476-1	YU187124	18GA X 48" X 120"						33								
75S43476-2	YU187124	18GA X 48" X 120"						33								
76S87832A-1	L2256A09	18GA X 60" X 120"						30								

We hereby certify that material described herein has been manufactured and tested with satisfactory results
in accordance with the requirement of the above material specification.

Heat: YU187124

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Preservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details:			